

Work Order ID 77365

December-06-11 10:30:24 AM

77365

Page 1

Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 06/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.L.JDate: 11/12/06 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

100

DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

8/12/02/06

MLJ 12-2-3**B77365**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side)								

JW 12-1-9

B 12/01/14

Dart Aerospace Ltd

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch: *M19712 BE 12-01-16*

12-Grind welds flush as per Dwg D2750 *SAD 12-01-19*

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo

0.00

S 12/01/19

Quality Control

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

S 12/01/19

Quality Control

W/O:		WORK ORDER CHANGES					
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77365

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N900040100

Setup Start ***NS1***

Stop *NS2*

*** 1 ***

*** 1 ***

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

140

0.00

MO

12/1/10

0.00

150

0.00

Quality Control



12-1-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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1

Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 119508

exp. date: 12/08/13

OK 12/01/20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: M119712

3 B12-01-23

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

OK 12/01/20

OK 12/01/20

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Stop ***NS2***

Start Date: 06/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

12/01/28

12/01/30

12/01/30

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 06/12/2011 Start Qty: 1.00

1

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Required Date: 20/12/2011 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Pressure Wash per QSI005 4.3

0.00

100

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 12-1-30

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8-40

OVEN TEMPERATURE: 320°F

FINISH TIME: 9-10

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1X 12/01/31

1 12/01/31

W119480

W/O:		WORK ORDER CHANGES					
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Setup Start ***NS1***

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Start Date: 06/12/2011 Start Qty: 1.00

1

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1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	HandFinishing					1	0	11	12/6/11 31
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
230		0.00							
230	HandFinishing					1	0	11	12/01/11
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: N/A								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 1119508 EXP DATE: 12/08								
	4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: 11110348								
	5-Coat all exposed fasteners with "LPS Procyon" batch: 1114596								

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Required Date: 20/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

Dart Aerospace Ltd

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

280

0.00

280

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

MF
12-02-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

December-06-11 10:30:27 AM

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Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	110.0000	8	8			
D3492-1									**			del 12/01/13	
Plug													

Location	Loc Qty	Loc Code
----------	---------	----------

FP-A	100	
------	-----	--

76235	100	
-------	-----	--

FP-B	10	
------	----	--

69531	8	
-------	---	--

74444	2	
-------	---	--

D3492-3		Manufactured	No			230	Each	109.0000	8	8			
D3492-3									**			del 12/01/13	
Plug													

Location	Loc Qty	Loc Code
----------	---------	----------

FP-A	40	
------	----	--

76236	40	
-------	----	--

FP-B	69	
------	----	--

74447	25	
-------	----	--

74871	44	
-------	----	--

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D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

183.0000

8

8

NAS1611-010

O-RING

**

11/20/21 M(x8) 12/01/31

Location

Loc Qty

Loc Code

FP

183

110915

14

117460

8

118077

1

118612

3

119438

107

119623

50

NAS1149D0863J

Purchased

No

250

Each

192.0000

2

2

NAS1149D0863.J

WASHER

**



Location

Loc Qty

Loc Code

ST298

192

118078

92

119307

100

118078

D2744

Manufactured

No

110

Each

41.0000

1

1

D2744

Cap

**

BE 12-01-11

Location

Loc Qty

Loc Code

LG002

41

62715

1

70881

12

71861

28

1

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D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

17.0000

1

1

D2600-3-BENT

Extrusion Bent

**

Location

Loc Qty

Loc Code

LG

17

66875

8

73253

1

75021

1

75022

6

75023

1

77623

160

Each

225.0000

8

8

**

① JW 12-1-9
BE12-01-23

D2743

Manufactured No

D2743

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

218

73403

64

74445

100

76141

54

LG001

7

67766

4

68251

3

8

D2739

Manufactured No

D2739

350 I Beam

160

Each

13.0000

1

1

**

78420

① DR 12/01/20

Location

Loc Qty

Loc Code

LG

13

72155

1

76866

1

76867

3

76987

8

Dart Aerospace Ltd

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160 Each 50.0000 4 4

D3490-3

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG001

50

74877

40

76234

10

BE2-01-23
B7567 x4

D3490-1 Manufactured No

160 Each 61.0000 4 4

D3490-1

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG001

61

62450

2

67773

4

74875

55

BE2-01-23
B77042 x4

ALS4-1032-225 Purchased No

220 Each 1,796.000 38 38

ALS4-1032-225

Insert

**

Location

Loc Qty

Loc Code

ST281

1796

108696

271

110768

62

118386

858

118966

605

11 12/01/31

X36

D3793-3 Manufactured No

230 Each 24.0000 1 1

D3793-3

Wearshoe

**

Location

Loc Qty

Loc Code

FP001

24

74528

8

74593

4

75043

12

11 12/01/31

X8

December-06-11 10:30:28 AM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

93.0000

1

1

AN8C35A

BOLT

**

12/01/31

Location

Loc Qty

Loc Code

FP

92

115960

1

117834

29

118286

62

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured

No

230

Each

20.0000

1

1

D3793-1

Wearshoe

**

12/01/31

Location

Loc Qty

Loc Code

FP001

12

75038

12

FP018

8

74591

8

D3488-041

Manufactured

No

230

Each

20.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

B77021 (x1) 12/01/31

Location

Loc Qty

Loc Code

FG008

9

75056

9

FP002

11

61689

1

67788

1

69903

4

71887

5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

23.0000

1

1

D3794-3

Gasket

**

12/01/31

Location

Loc Qty

Loc Code

FP002

23

74530

9

74596

14

AN6C44A

Purchased

No

230

Each

83.0000

4

4

AN6C44A

BOLT

**

12/01/31

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

81

118985

40

119125

30

119530

11

MS21083C8

Purchased

No

230

Each

78.0000

1

1

MS21083C8

NUT

**

12/01/31

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

76

115884

0

118614

23

119309

3

119436

25

119638

25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25 Manufactured No

230 Each 31.0000 1 1

D3536-25

Gasket

**

11 12/01/31

Location

Loc Qty

Loc Code

FP012

31

74595

5

75039

26

D3631-1 Manufactured No

230 Each 447.0000 8 8

D3631-1

Washer

**

11 12/01/31

Location

Loc Qty

Loc Code

ST072

447

68062

2

75548

445

D3791-1 Manufactured No

230 Each 31.0000 1 1

D3791-1

Wearplate

**

11 12/01/31

Location

Loc Qty

Loc Code

FP002

16

75041

16

FP017

15

62239

2

74527

1

74598

12

AN960C10L Purchased No

230 Each 0.0000 38 38

***AN960C10L ***

washer

**

1119736 (x38) 11 12/01/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

85.0000

8

8

D2745

Bushing

**

B 76.142(x8) ll 12/01/31

Location

Loc Qty

Loc Code

FP

85

69529

1

71835

12

74446

72

AN3C5A

Purchased

No

230

Each

1,278.000

34

34

AN3C5A

Bolt

**

ll 12/01/31

Location

Loc Qty

Loc Code

FP

7

115835

7

ST350

1271

116419

28

117343

17

117764

49

117872

2

118451

175

119127

500

119749

500

28

6

D3537-1

Manufactured

No

230

Each

100.0000

3

3

D3537-1

Wearpad

**

B 77.560(x3) ll 12/01/31

Location

Loc Qty

Loc Code

FP002

95

74436

23

74867

72

FP017

5

69817

5

376

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-06-11 10:30:28 AM

Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

325.0000

1

1

NAS1149C0832R

WASHER

**

Jul

12/01/31

Location

Loc Qty

Loc Code

ST297

325

114915

325

X1

AN3C6A

Purchased

No

230

Each

318.0000

4

4

AN3C6A

BOLT

**

Jul

12/01/3

Location

Loc Qty

Loc Code

FP

1

111982

1

ST351

317

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

62

119449

100

119749

100

X4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

176.0000

8

8

NAS1611-013

O-RING

**

11/12/0121 (x8) 11/12/0131

Location

Loc Qty

Loc Code

FP

176

116582

5

117291

2

117887

53

119307

72

119438

2

119623

42

D3535-25

Manufactured

No

230

Each

27.0000

1

1

D3535-25

Wearshoe

**

11/12/0131

Location

Loc Qty

Loc Code

FP001

17

74525

5

75040

12

FP018

10

62233

1

74592

9

D3794-1

Manufactured

No

230

Each

41.0000

1

1

D3794-1

Gasket

**

11/12/0131

Location

Loc Qty

Loc Code

FP014

41

74529

1

74594

12

75042

28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-06-11 10:30:28 AM

Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

425.0000

4

4

MS21043-6

NUT

**

44 12/6/13

Location

Loc Qty

Loc Code

FG

20

103693

20

ST300

405

112314

195

117887

10

118384

200

x4

D3493-1

Manufactured

No

250

Each

45.0000

2

2

D3493-1

Washer

**

77573

Location

Loc Qty

Loc Code

ST062

45

70697

4

71846

11

76237

30

MS21083C8

Purchased

No

250

Each

78.0000

2

2

MS21083C8

NUT

**

12/1/12 12/2/13

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

76

115884

0

118614

23

119309

3

119436

25

119638

25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

55.0000

2

2

**

AN8C21A

BOLT

Location

Loc Qty

Loc Code

ST343

55

118045

5

118758

20

119530

30

119530

NAS1515H3L

Purchased

No

230

Each

131.0000

4

4

**

***NAS1515H3I ***

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

91

118686

3

119438

88

XJ

D2741

Manufactured

No

250

Each

38.0000

1

1

**

D2741

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-4

71856

6

ST466

42

71856

32

71856 12/27/3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 13

Work Order ID: 77365

77365

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 06/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

42.0000

2

2

D3532-1

Spacer

**

B 78837 C/12/18 C

Location

Loc Qty

Loc Code

ST065

42

73342

2

74880

40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 77365-M.C.J
11/12/06

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B6-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC.	
DRAWN	RAH	PORT HADLOCK, WA	
CHECKED	RAH	DRAWING NO.	REV. F
MFG. APPR.	RAH	D2750	SHEET 1 OF 11
APPROVED	RAH	TITLE	SCALE
DE APPR.	RAH	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

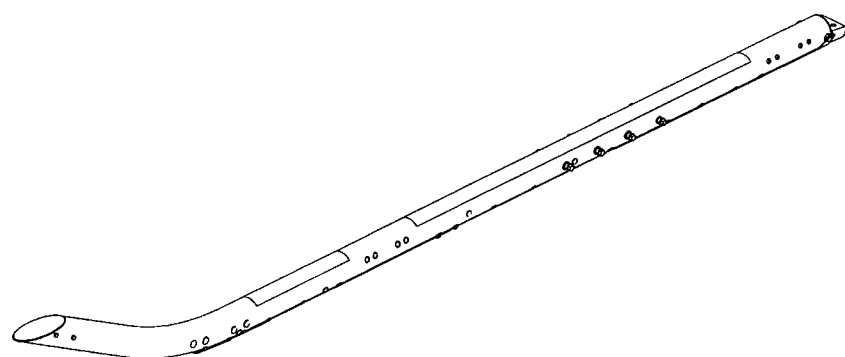
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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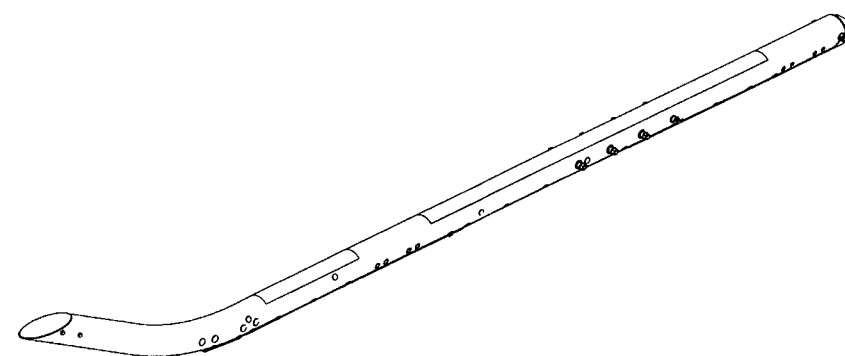
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77365



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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58-09-22-100

DESIGN	PCN	DART AEROSPACE USA, INC.	
DRAWN	LM	PORT HADLOCK, WA	
CHECKED	JA	DRAWING NO.	REV. F
MFG. APPR.	MY	D2750	SHEET 2 OF 11
APPROVED	MY	TITLE	SCALE
DE APPR.	MY	350 SKIDTUBE ASSEMBLY	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

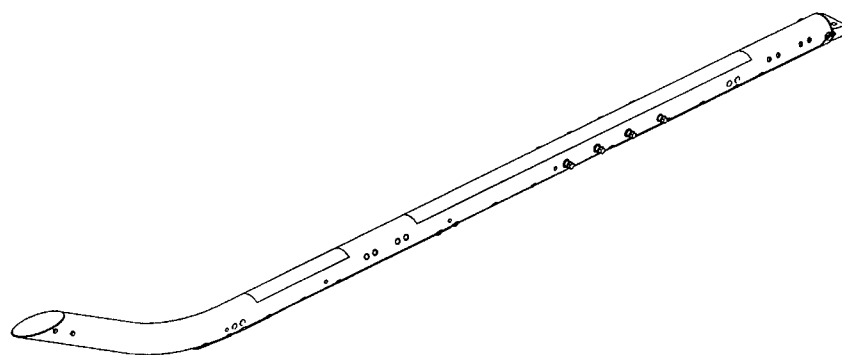
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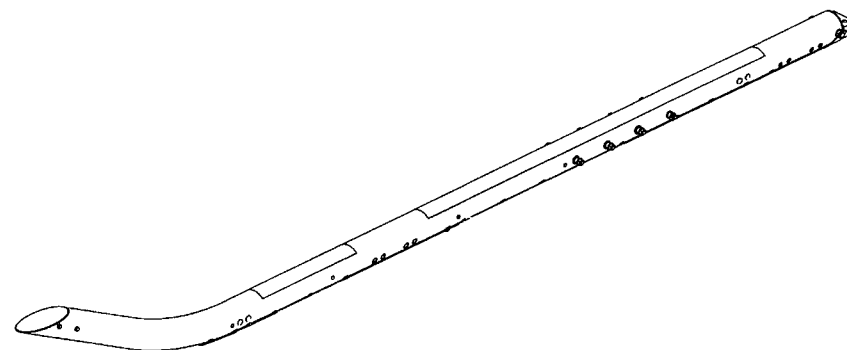
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77365



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
68-9-22/111

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	NA	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

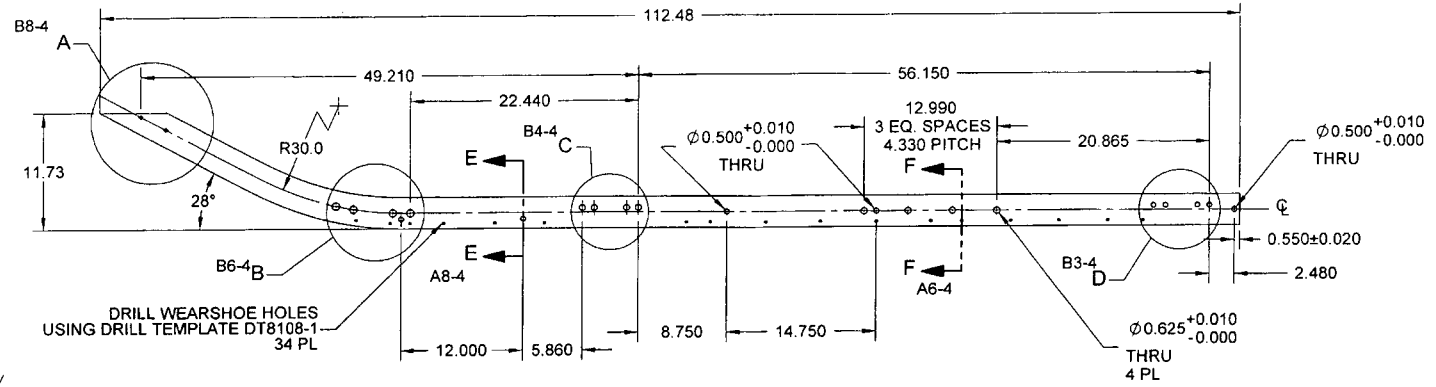
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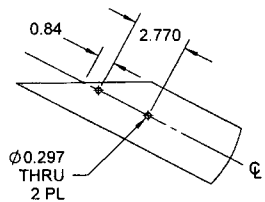
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

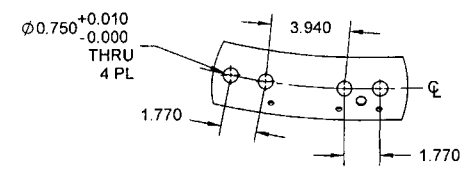
77365



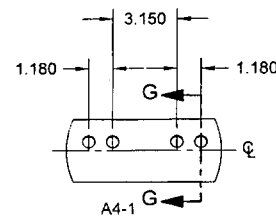
D2750-1 LH SKIDTUBE



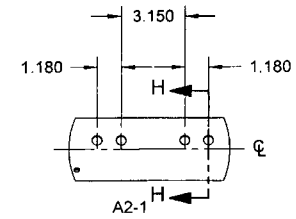
DETAIL A
SCALE 2X



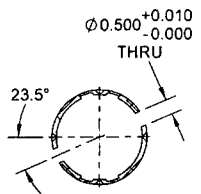
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SCALE 2X



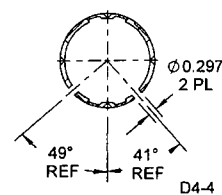
DETAIL C
SCALE 2X



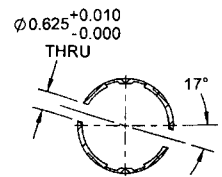
DETAIL D
SCALE 2X



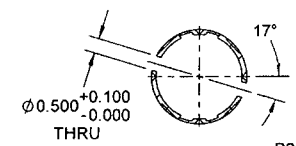
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.		SHEET 4 OF 11	
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DATE	08.07.16	NTS	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

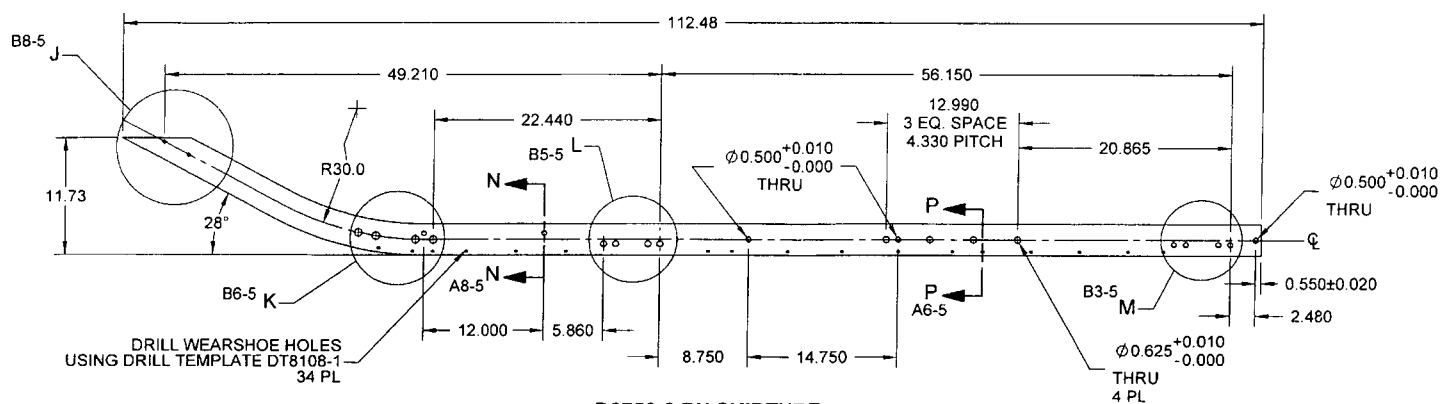
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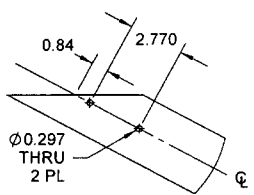
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

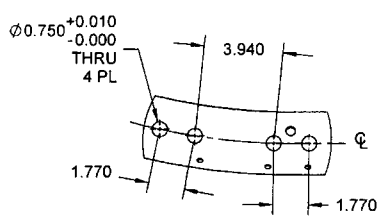
77365



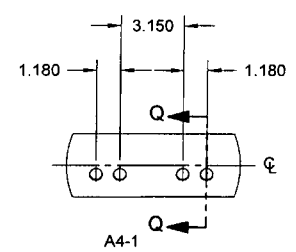
D2750-2 RH SKIDTUBE



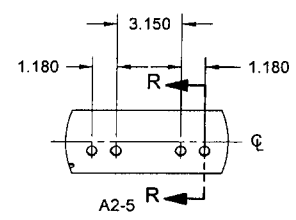
DETAIL J
SCALE 2X



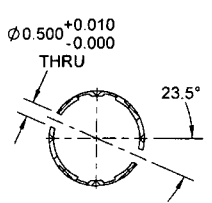
DETAIL K
SCALE 2X



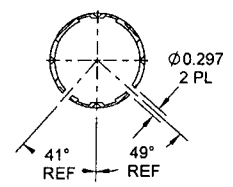
DETAIL L
SCALE 2X



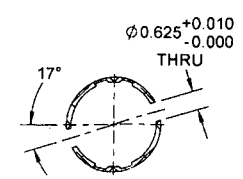
DETAIL M
SCALE 2X



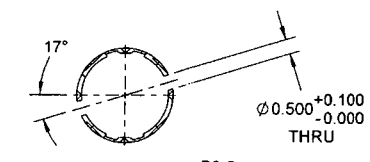
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
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MFG. APPR.		D2750	SHEET 5 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

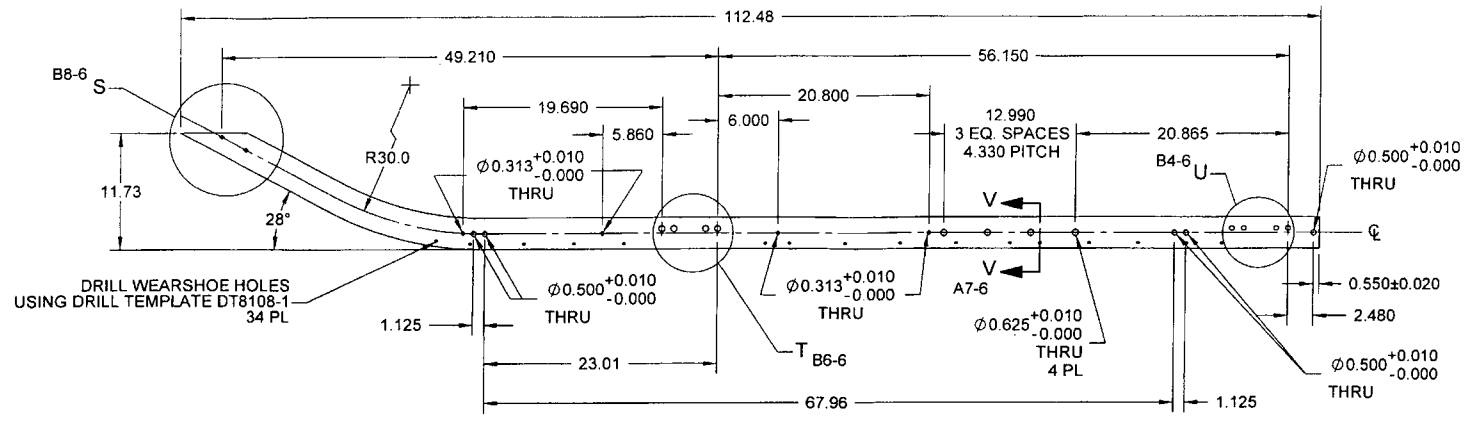
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

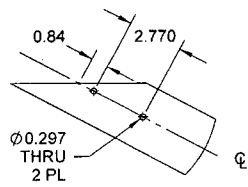
NOTE: Date & initial all entries

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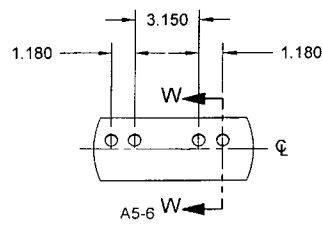
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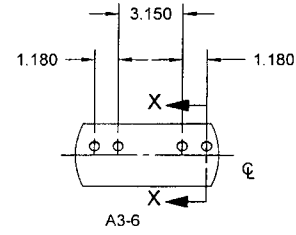
D2750-3 LH SKIDTUBE



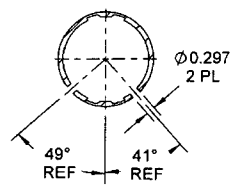
DETAIL S
SCALE 2X
D8-6



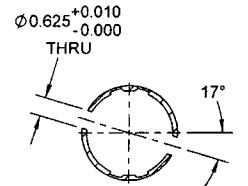
DETAIL T
SCALE 2X
C5-6



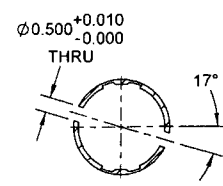
DETAIL U
SCALE 2X
D3-6



SECTION V-V
SCALE 3X, 17 PL
C4-6



SECTION W-W
SCALE 3X, 4 PL
B6-6



SECTION X-X
SCALE 3X, 4 PL
B4-6

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08-22-11

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.			SHEET 6 OF 11
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

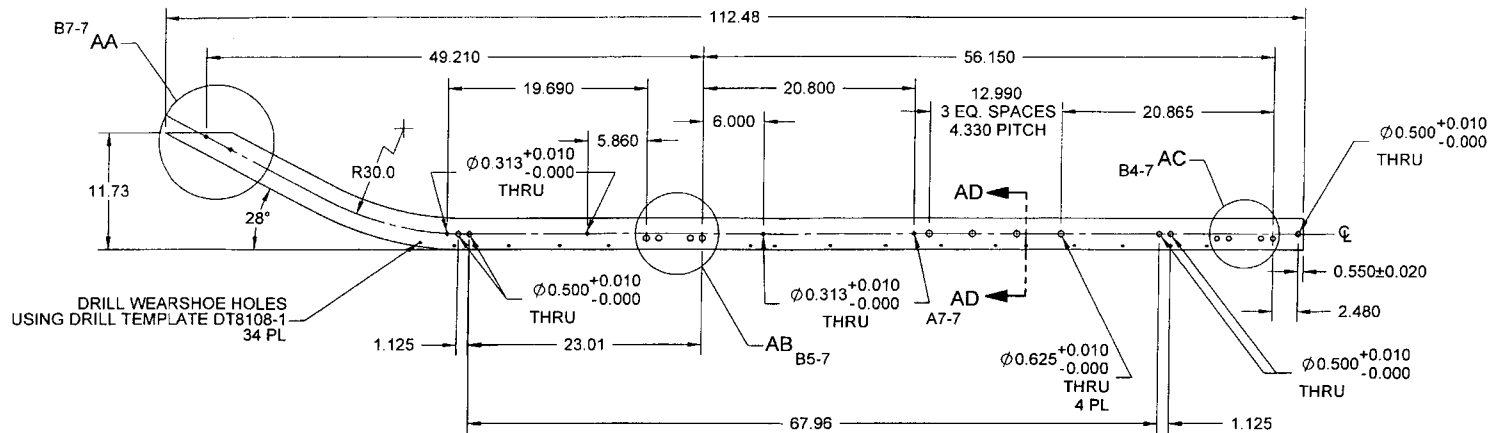
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

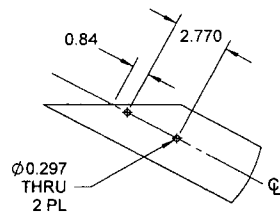
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

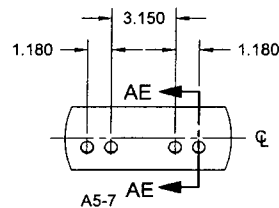
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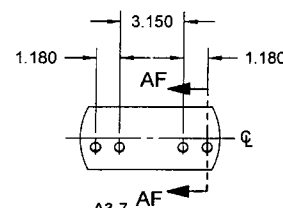
D2750-4 RH SKIDTUBE



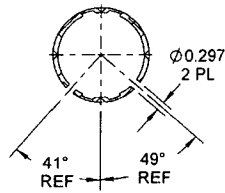
DETAIL AA
SCALE 2X



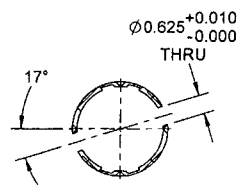
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SCALE 2X



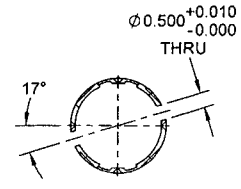
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

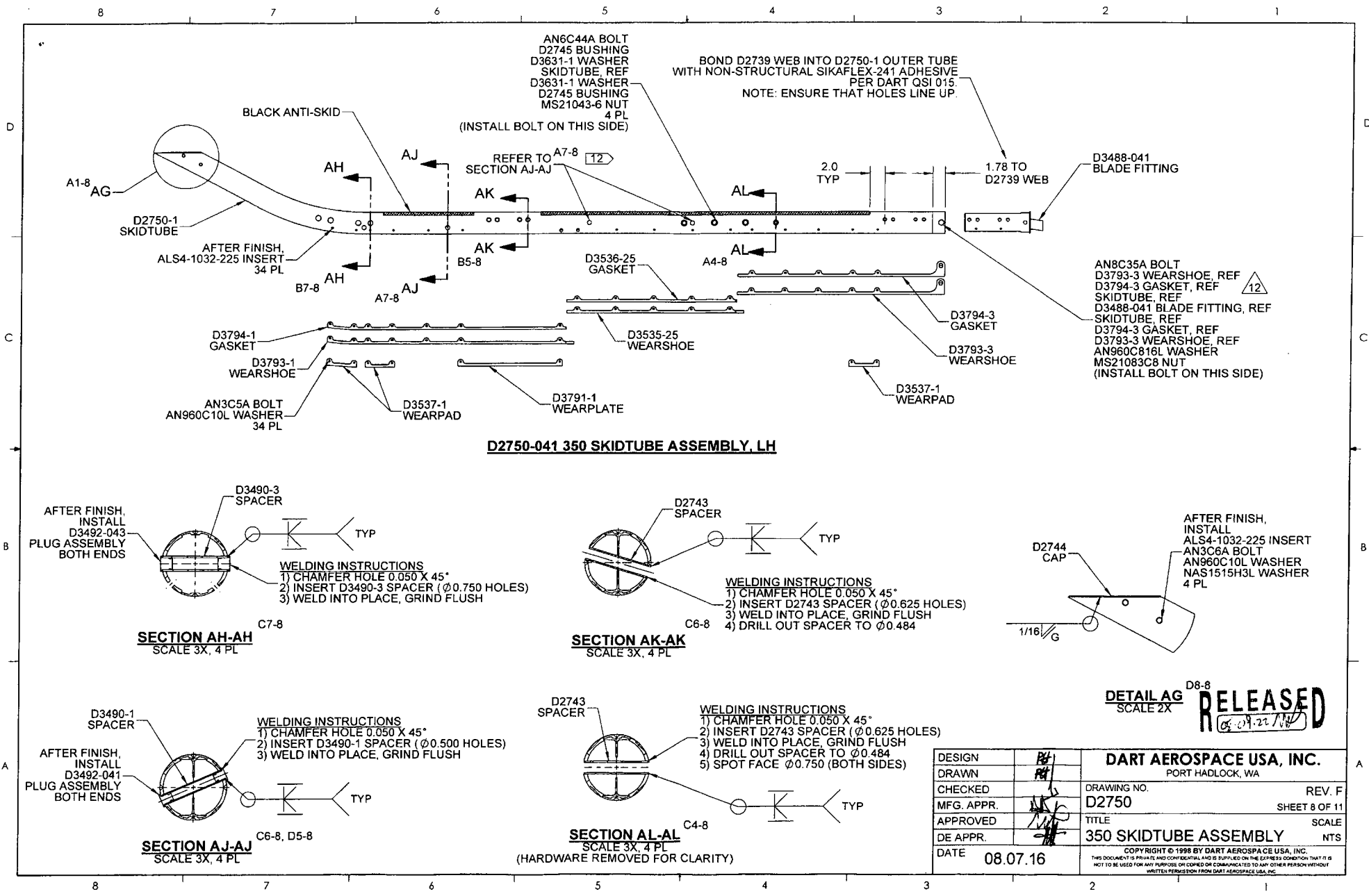
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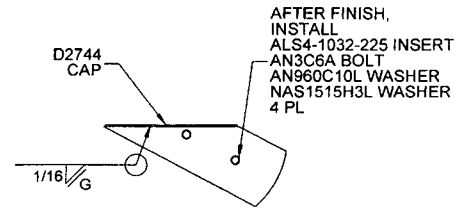
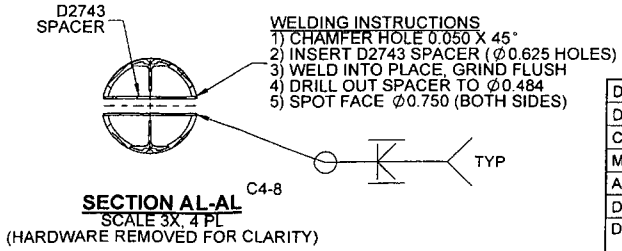
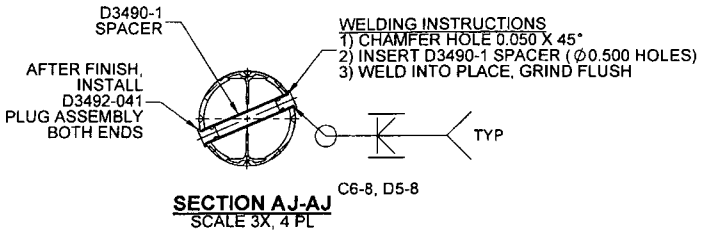
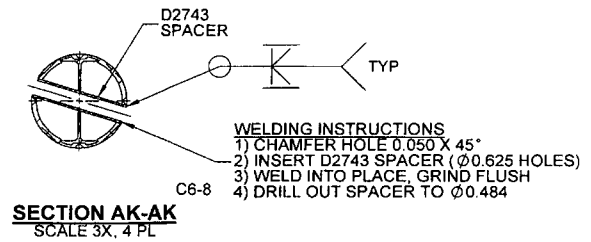
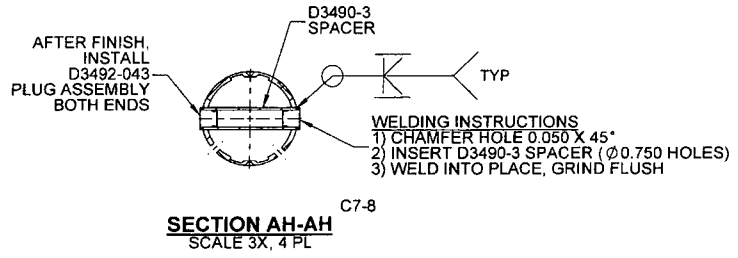
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



DETAIL AG D8-8
SCALE 2X
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DESIGN	REV. F	DART AEROSPACE USA, INC.	
DRAWN	REV. F	PORT HADLOCK, WA	
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MFG. APPR.		D2750	SHEET 8 OF 11
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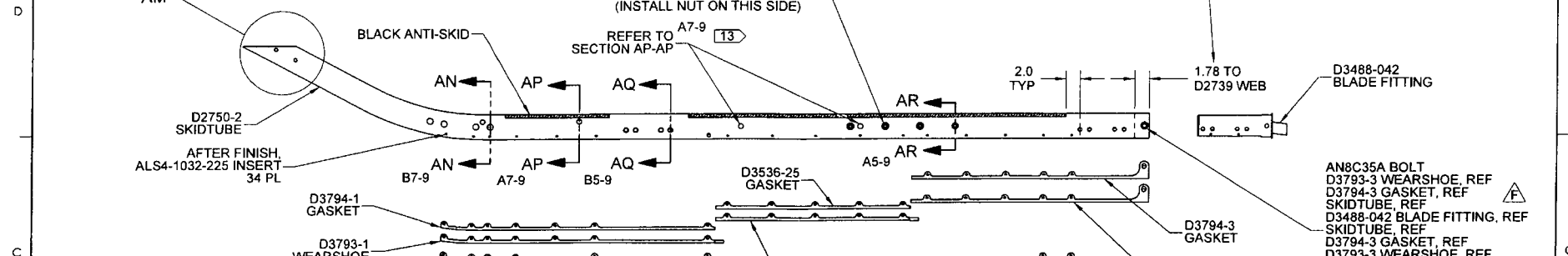
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

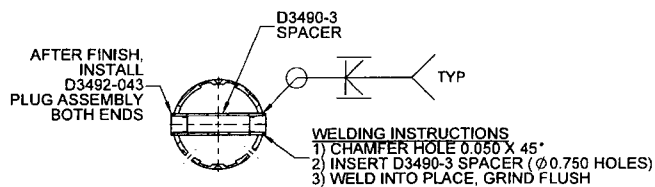
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

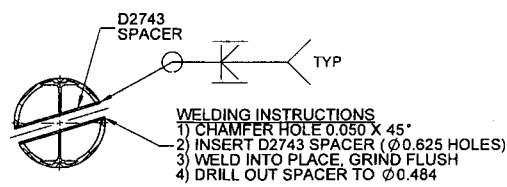
NOTE: Date & initial all entries



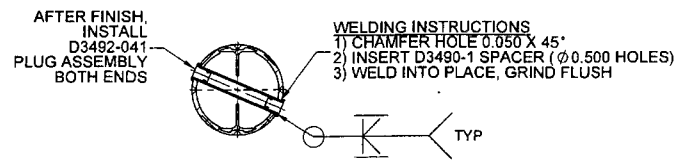
D2750-042 350 SKIDTUBE ASSEMBLY, RH



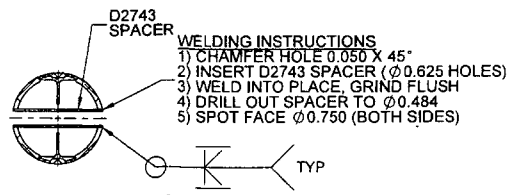
SECTION AN-AN
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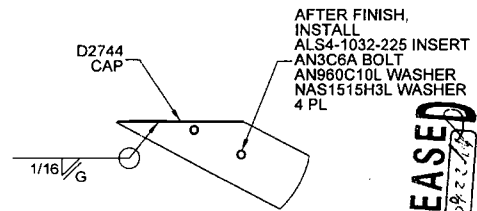
SECTION AQ-AQ
SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL



C4-9
SECTION AR-AR
SCALE 3X, 4 PL
(PANELS REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 9 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

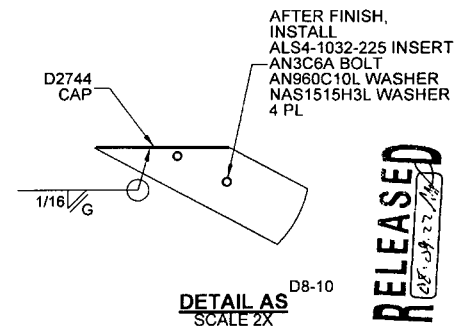
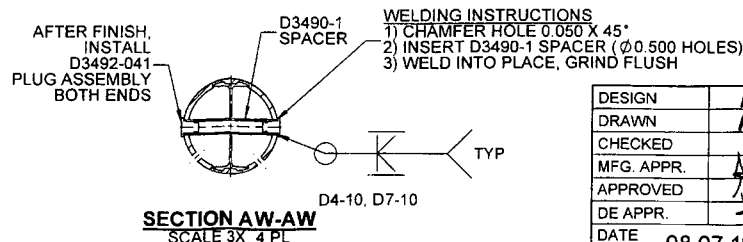
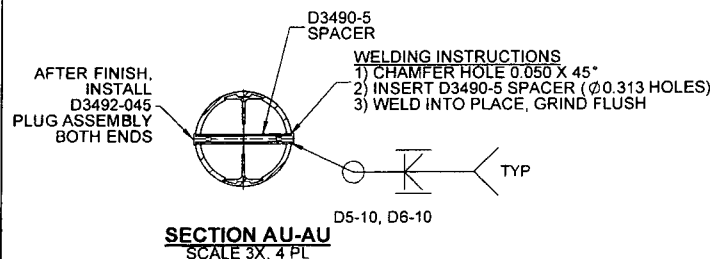
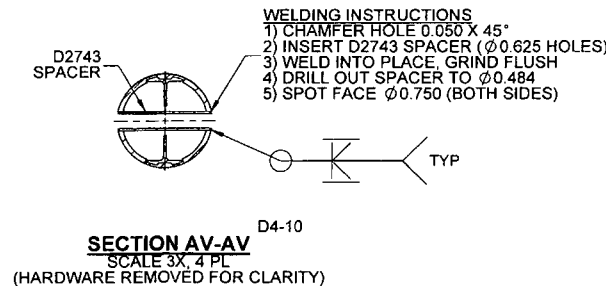
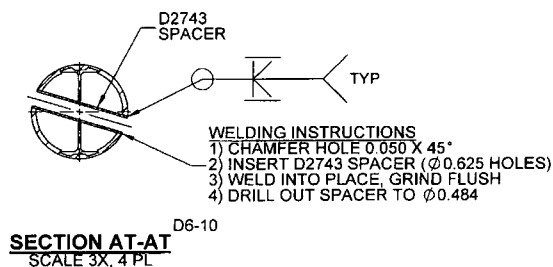
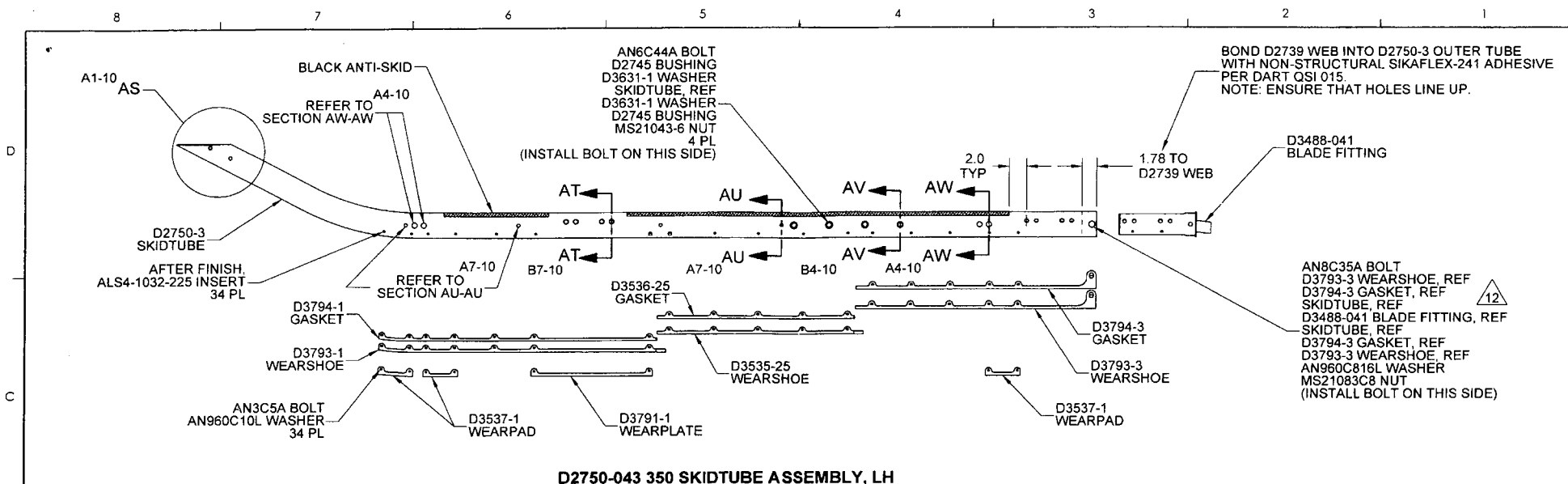
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77365



DESIGN	AS	DART AEROSPACE USA, INC.	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 10 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
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RELEASED
28 JUL 27 1988

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

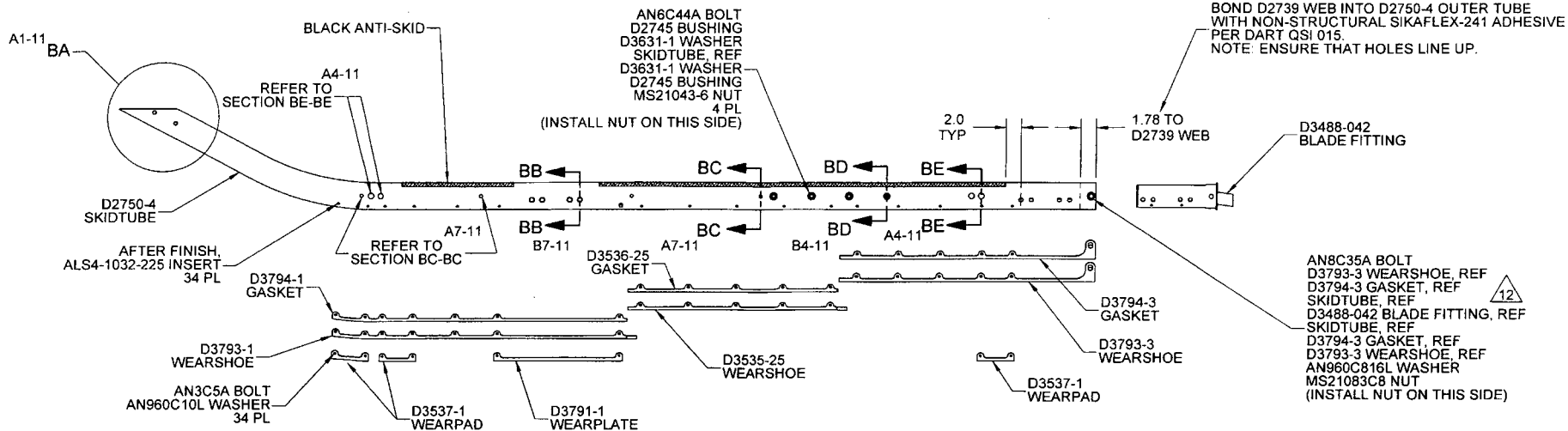
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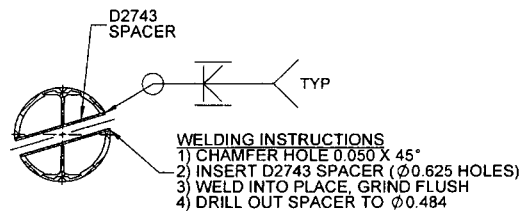
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

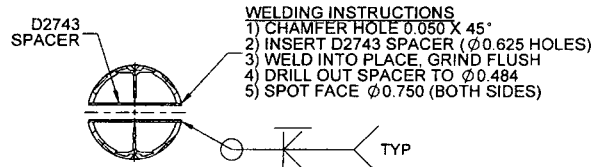
77365



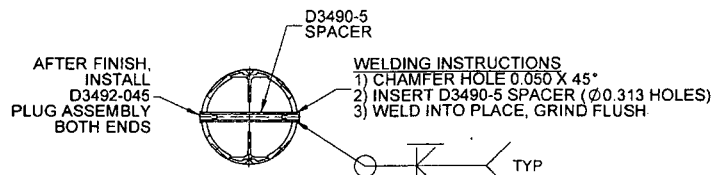
D2750-044 350 SKIDTUBE ASSEMBLY, RH



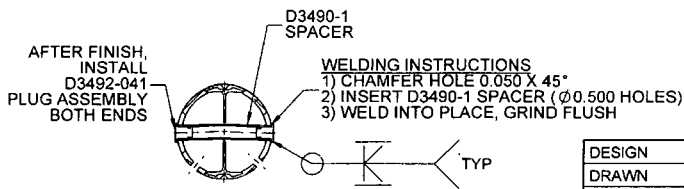
SECTION BB-BB
SCALE 3X, 4 PL



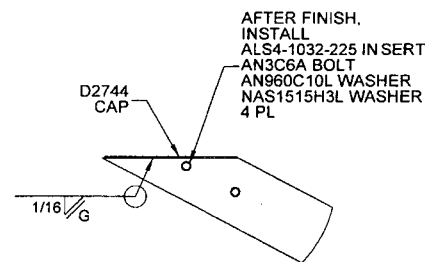
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 279

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 77362
Part number: D 350 636 012
Description: 350 skidsteer
Welding Process: Tig ☒ Mig ☐
Base material: aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Lewis Date of Test Coupon 11.12.22
Welder Barclay Elliott Date of Test Coupon 11.12.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld